Work Orde		1039		*121	1039*							Page 1	
Item ID: Revision ID:	D3436-044			Accept	*N900	040	100)*	Setup	Start	"IVI.	S1*	
Item Name:	Step RH									Stop	*N:	S2*	
Start Date:	6/16/14	Start Qty: 1.00	*1*		Cust Item	ID:							
Required Date:	6/16/14	Req'd Qty: 1.00	*1*		Customer:								
Reference:							_		Run	Start			
Approvals:	Process Pla	n: <u>M</u> LJ	Date: 14-06-1	Tooling:	D	ate:			Kuli		*N	R1*	
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	•	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr	,	•								111	
D3436	Rev	A										14-09	10
100				0.00				1				é	P)
100 Large Fab		Large Fab Memo		0.00									, -
Large Fab		Dwg D3436 Qty Part A/RN/A Weld right s Rev: Qty Part A/RN/A Weld cap D	ngs D3436-5 and clamp D DDWg Rev: Number Description 4130 Welding Rod DDWG Welding Rod NumberDescription 4130 Welding Rod DDGGGGGGGGGGGGGGGGGGGGGGGGGGGGGGGGGGG	Barch g Jig DT8773 and Dwg I 2 3 925 Dwg Rev: A Batch								at	

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE												
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA			_	_	AEROSPACE				
QA Closed:		Date:		-			,:		W	ork Order up	date only	\perp					
Work Orde	er:				DISPOSITION		-	A	AGAINST DE	PARTMENT	/PROCESS						
				_	Rework	1		Skid-tube Cr	rosstube	1	Water Jet	\neg	Engineering				
Part N	lo.				Scrap			—	mall Fab	Pro	d. Eng. Coor.	٦	Quality				
					Use-as-is				Finishing	4	re/Packaging		Other				
NCR N	lo			-	Suspected Unapproved			Large Fab Co	mposite]	Supplier						
Root				Descr	ription of work order update		Initial	Action		Sign &		T					
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	on	Date	Verification		QC Inspector				
Design																	
Doc/Data												١					
quip/Tooling																	
landling/Pre																	
Material	_																
Operator																	
Offset/Setup							,										
rocess																	
Supplier																	
raining	_																
ransport	_				*							- [
Jnapproved			L			l											
						FAI	ULT CA	TEGORY		****							
Landin F	ng Gear				General		1			1		_					
}	Bending			_	Bend		1	Program	<u> </u>	Outside Dim	_	_	Pressure/Forced				
-	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	-		Set-up				
	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred	-	_	Temperature/Cure				
-	Crimp/Kink/Ripple/Wave				Burrs	L	1 '	ion Incomplete/Unquali	_	Part Lost/Mi	ssing	_	Weld				
-	Crushing				Contamination	H	4	tions Incomplete/Unclea	ar	Part Moved	<u></u>	ا	Wrong Stock Pulled				
-	Crushing				Countersink		1	gned/off center	<u> </u>	Positioned W		٦.	DAI:				
}	Heat Trea		T., L -	<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	(Other				
}	Inspection	•	eauı		Drawing Drill Holos	-	Misrea										
}	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set										
}	Turning So	•			Finish	\vdash	-	Calibration					Y				
	Wave/Tw	ist in Tub	<i>э</i> е		Fit/Function	L	Jout of !	Sequence									

Work Orde June-16-14 1:16		1039		*191	039*							Page 2
Item ID: Revision ID:	D3436-044			Accept	*N900	040	100)*	Setup	Start Stop		S1*
Item Name:	Step RH									Stop	*N:	S2*
Start Date:	6/16/14	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	6/16/14	Req'd Qty: 1.00	*1*	1	Customer:							
Reference:			-						_	C 4 4		
Approvals:	Process Pla	nn:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*
	QC:		_ Date:	_ SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
110				0.00					i			14-09
*11 0 *		BAND SAW		0.00				5	<u> </u>			
Bandsaw		Memo	2426.041	0.00								\mathcal{L}
Jeaspa Bandsaw		1-Slit part E 2- deburr	3436-041 on bandsaw as	per Dwg D3436								O
120		QC9- Inspect visual per	QSI004- Fusion Welds	0.00				,	S	EP 1	0 2014	DAS 24 9-89
120				0.00								
QC		Мето		0.00								•
Quality Control		•										
					•							
130		QC5- Inspect part compl	leteness to step on W/O	0.00				4	SI	EP 10	2014	DAS 24
130												9-89
QC		Memo		0.00				•				

Memo

Quality Control

DQA:		_ Date:										TRACE
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA				AEROSPACE
QA Closed:		Date:							Wo	ork Order up	date only	
Work Orde	er:				DISPOSITION			A	GAINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo.				Scrap			—	mall Fab	Pro	d. Eng. Coor.	Quality
			*		Use-as-is		Therr	noforming F	inishing	Rec/Stor	e/Packaging	Other
NCR N	lo			_	Suspected Unapproved			Large Fab Cor	mposite		Supplier	
Root				Desci	ription of work order update		nitial	Action		Sign &	- • • • • • • • • • • • • • • • • • • •	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material	_											
Operator								İ				
Offset/Setup	_				·							
Process												
Supplier												
Training	155 F	E. 1						·				
Transport	_	l										
Unapproved		<u> </u>	L					FECORY				
Landin					*****	FAU	JLI CA	TEGORY				
Landir	ng Gear Bending				General Bend		 	Program		Outside Dim]p/r/
	Centre No	ot Concor	ntric	-	BOM/Route	Н	Grain	Togram		Over/Under		Pressure/Forced Set-up
2.57	Cracks			\vdash	Broken/Damage/Defect		Hardwa	aro.		Part Incorred		Temperature/Cure
	Crimp/Kir			\vdash	Burrs		l	ire ion Incomplete/Unqualit	find	Part Lost/Mi		Weld
}	Cuffs	ny mphie	, wave	-	Contamination	\vdash		tions Incomplete/Unclea		Part Lost/Will	231118	Wrong Stock Pulled
ŀ	Crushing				Countersink	\vdash	1	gned/off center		Positioned W	L /rong	Jerrong Stock runeu
}	Heat Trea			\vdash	Cut Too Short	\vdash	Mislabe			Power Loss/S		Other
}	Inspection		Tube		Drawing	\vdash	Misrea		.	1 2		
•	Marks/Ch		-		Drill Holes		Off-set					
	Turning S				Finish		ł	Calibration				·
	Wave/Tw				Fit/Function			Sequence			400	

Work Orde June-16-14 1:10		1039		*121	1039*							Page	; 3
Item ID: Revision ID: Item Name:	D3436-044 Step RH			Accept	*N <u>9</u> 00	040	100)*	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date: Reference:	6/16/14 6/16/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 140 *1 10* Powdercoat Powder Coating	D .	Operation Description White Gloss(Ref: 4.3.5.2) Memo START TIN OVEN TEM FINISH TIN	D9 _{ME:}	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rejo		Reject Number	Insp. Stamp	- 248 989
145 *1 15* HandFinish Hand Finishing		Мето	QSI005 4.4 Batch 1/1(12 B/111(29 8 17	_9 6 6.F			×	1R41		(90	11/09	<u> </u>
													/ DA

150

QC3- Inspect Part Finish

0.00

150

Memo

0.00

Quality Control

DQA:		Date:												TQAG
DA Clasadi		Data			WORK ORDER NON	-CC	ONFO	RMANCE / UPI		147.	- ul. Oud - u			AEROSPACE
QA Closed:		Date:								VV	ork Order up	date only	I	
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	lo.				Scrap	1 1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is	1	Therr	noforming	Finishing		1	re/Packaging	\vdash	Other
NCR N	lo			_	Suspected Unapproved]		Large Fab	Composite]	Supplier		
Root	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			Desci	ription of work order update		nitial	Actio	n		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion		Date	Verification	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator	_													
Offset/Setup														
Process														
Supplier	_												•	
Training										•				•
Transport														
Unapproved			<u></u>	<u> </u>				<u> </u>	··					
- 						FAI	ULT CA	TEGORY						
Landir F	ng Gear				General		1		г		1			!
·	Bending			<u> </u>	Bend	\vdash	•	Program			Outside Dim		-	Pressure/Forced
-	Centre No	ot Concei	ntric	ļ	BOM/Route	\vdash	Grain		ļ. ļ		Over/Under		-	Set-up
}	Cracks		4	_	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred		\vdash	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs	\vdash	ŧ .	ion Incomplete/Unqu	i i		Part Lost/Mi	ssing	\vdash	Weld
	Cuffs				Contamination	\vdash	4	tions Incomplete/Un	clear		Part Moved			Wrong Stock Pulled
}	Crushing			-	Countersink	\vdash	1	gned/off center			Positioned V	-		OU.
}	Heat Trea		Tt.		Cut Too Short	\vdash	Mislabe		Ĺ		Power Loss/	Surge		Other
ļ	Inspectio	-	Tube		Drawing	<u> </u>	Misrea					•		
	Marks/Ch			-	Drill Holes	-	Off-set							
	Turning S			<u> </u>	Finish Fit/Function		4	Calibration						
	- IVVAVE/IV	ust in till	1 2		LEU / EUDCTION	1	II HIT OT '	SAUTIONCO						

Work Orde June-16-14 1:10		1039		*121	1039*						Page	4
Item ID: Revision ID: Item Name:	D3436-044 Step RH			Accept	*N900	040	100) *	Setup Star Stop	I VI	S1* S2*	
Start Date: Required Date: Reference:	6/16/14 6/16/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	ID:						
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:		F	Run Star	"17	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	, *N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
155				0.00				1./			ullo	DAS 38
155 Small Fab		Memo		0.00							14/07/	/\\)9-89
Small Fab			er dwg and QSI 015								,	
160		QC5- Inspect part compl	eteness to step on W/O	0.00							DAS 38	
160 QC Quality Control		Memo		0.00				l			9-89	4-9-16
Quality Control					·							
170		Identify as per dwg & Sto	ock Location: <u>PP 12</u>	1188 0.00					. مس	R	7	
170 Packaging		Memo		0.00					<u> </u>	6,149	16	-

Packaging

DQA:		Date:	:													
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	14/	ork Ordor w	ndata anku - F		AEROSPACE			
QA Closed.		Date				_	1		VV	ork Order up	date only					
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS					
			* -		Rework	ll		Skid-tube Crosstube	·L		Water Jet	☐ En	gineering			
Part N	lo.				Scrap			Machining Small Fak	-	Pro	d. Eng. Coor.		Quality			
					Use-as-is		Therr	moforming Finishing	<u>,</u>	-1	re/Packaging		Other			
NCR N	lo				Suspected Unapproved			Large Fab Composite	:[]	Supplier					
Root		1		Docc	ription of work order update		nitial	Antion		Cian 0		Ι.				
Cause	Date	Step	Qty	Desci	or non-conformance	ı	initial iief Eng	Action		Sign & Date	Verification	Ι,	OC Inspector			
Design	Date	зсер	Qty		of non-comormance	CII	ilei ciig	Description		Date	verification	+-	QC Inspector			
Doc/Data																
Equip/Tooling																
Handling/Pre	7															
Material																
Operator	_															
Offset/Setup]															
Process																
Supplier																
Training																
Transport																
Unapproved																
··-						FA	ULT CA	TEGORY								
Landi	ng Gear				General					_		_				
	Bendin	g			Bend		Folio/F	Program		Outside Dim	ensions	Pres	sure/Forced			
	Centre	Not Conce	ntric	<u> </u>	BOM/Route		Grain	•	<u>_</u>	Over/Under	tolerance	_ Set-	up			
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	et	Tem	perature/Cure			
		Kink/Ripple	e/Wave	_	Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	d			
	Cuffs			<u> </u>	Contamination	-	1	tions Incomplete/Unclear	_	Part Moved		Wro	ng Stock Pulled			
	Crushing				Countersink	_	-	gned/off center		Positioned V		_				
	Heat T			<u> </u>	Cut Too Short	\vdash	Mislabe			Power Loss/	Surge	Othe	r			
	─	tion Strip ir	1 Tube	\vdash	Drawing	_	Misread									
		'Chatter		<u> </u>	Drill Holes	\vdash	Off-set									
	_	g Sequence		-	Finish	<u> </u>	1	Calibration -								
	Wave/	Twist in Tu	be		Fit/Function	L_	Out of S	Sequence								

Work Ord June-16-14 1:1		21039		*121	1039*							Page 5
Item ID: Revision ID: Item Name: Start Date: Required Date	D3436-044 Step RH 6/16/14 :: 6/16/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*	Accept	*N900 Cust Item I		100)*	Setup	Start Stop		S1* S2*
Reference:		,	1		U							
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	I D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp
180		QC21- Final Inspection	- Work Order Release	0.00						/	/	10
*1 A \ C \ QC \ Quality Control		Memo		0.00					[4/	7/11	754

J4-4-16

DQA:		Date:	WORK ORDER NON-CONFORMANCE / UPDATE												
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPI		Vork Order u	ndate only	AEROSPACE			
a, rotosca.		- Date.			DISPOSITION	,									
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
					Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part N	10			:	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR N	lo				Suspected Unapproved			Large Fab	Composite	_	Supplier	J LJ			
Root	<u> </u>			Desci	ription of work order update		nitial	Actio	n	Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector			
Design		ļ		1											
Doc/Data		1													
Equip/Tooling	_														
Handling/Pre	_									ŀ					
Materia!	7														
Operator		1													
Offset/Setup	_	1													
Process															
Supplier	_	:													
Training]							
Transport	_														
Unapproved		<u> </u>		i		<u> </u>				<u> </u>	<u> </u>				
						FAL	ULT CA	TEGORY							
Landir	ng Gear				General] = . v . /s		Г	٦	. –	7. /.			
مسد	Bending			ļ	Bend BOM/Route	_	1	Program	-	Outside Dim	_	Pressure/Forced			
ŀ		lot Conce	ntric		BOM/Route	-	Grain		-	Over/Under	-	Set-up			
ł	Cracks	ink/Binnla	Maya		Broken/Damage/Defect	-	Hardwa		alified	Part Incorre		Temperature/Cure Weld			
,	Crimp/Kink/Ripple/Wave				Burrs Contamination	\vdash	1	ion Incomplete/Unqu	-	Part Lost/Mi	SSILIB	┥			
	Cuffs Crushing				Countersink	-	1	tions Incomplete/Un gned/off center	Lied!	Part Moved Positioned V	L Vrong	Wrong Stock Pulled			
ŀ	Heat Tre			-	Cut Too Short		Mislabe		-	Power Loss/	_	Other			
ŀ		on Strip in	Tube		Drawing	\vdash	Misrea		L			Totale			
	Marks/C	•		<u> </u>	Drill Holes	-	Off-set								
ł		Sequence			Finish	\vdash	4	Calibration		-					
		vist in Tul		ļ	Fit/Function	H	4	Sequence							
					1			<u> </u>							

Picklist Print June-16-14 1:16:51 PM Work Order ID: 121039 *121039* D3436-044 *D3436-044* Parent Item: **Start Date:** 6/16/14 Required Date: 6/16/14 Parent Item Name: Step RH Start Qty: 1.00 IPP A 05.05.11New IssueKJ/JLM **Comments:** Replacement Mfg/ Bin Primary Last Route Unit of Qty on Qty per Kit Total Qty Date Component Item ID/ Seq ID Measure Hand **Item Name** Item ID Purch Item Location Location **Oty Issued** Issued 37.0000 D3436-5 No 100 Each Manufactured ** Bushing Location Loc Qty Loc Code WA002 37 105968 12 (110527) 21 97483 4 16.0000 100 Each D3436-7 Manufactured No ** *D3436-7* Cap Loc Oty Loc Code Location WA002 16 16 17.0000 D3436-9 100 Each Manufactured No ** *D3436-9* Pad Loc Oty Loc Code Location GA 1 97337 1 ST042 16 105682 16 100 4.0000 1 D3436-4 Manufactured No Each ** *D3436-4*

Right Step

Loc Code Location Loc Qty WA002

4 97510

Page 1

Status

Required Qty: 1.00

DQA:		_ Date:				DART											
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT		ork Order up	ndate only	AEROSPACE					
					DISPOSITION			Δ		PARTMENT							
Work Orde	er:				_				_	. ,,	_						
Part N	lo.				Rework Scrap			—	osstube nall Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality					
raiti	····			!	Use-as-is			~ 	inishing	•	e/Packaging	Other					
NCR N	lo				Suspected Unapproved		inen	~ —	nposite	1 1100	Supplier						
Post		T		Dosc	rintian of work order undate		nitial	Action		Cian 0							
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance		initial iief Eng	Action Description		Sign & Date	Verification	OC Inchestor					
Design	Date	Step	Qty		of fion-comormance	CII	ner Eng	Description	1	Date	verincation	QC Inspector					
Doc/Data	\dashv																
Equip/Tooling	\dashv																
Handling/Pre																	
Material	_							2		,							
Operator																	
Offset/Setup																	
Process																	
Supplier																	
Training					_												
Transport												<i>'</i>					
Unapproved																	
						FAI	ULT CA	TEGORY									
Landi	ng Gear	*			General												
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced					
	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up					
`;	Cracks	*			Broken/Damage/Defect	$ldsymbol{ld}}}}}}$	Hardwa	ire		Part Incorred	i _	Temperature/Cure					
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualifi	ied	Part Lost/Mi	ssing	Weld					
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear	r <u> </u>	Part Moved		Wrong Stock Pulled					
	Crushing				Countersink		1	gned/off center		Positioned W	_	_					
	Heat Tre				Cut Too Short	-	Mislabe			Power Loss/S	Surge	Other					
		on Strip in	Tube		Drawing		Misread										
	Marks/C			<u> </u>	Drill Holes		Off-set										
	→ -	Sequence	- 6		Finish		4	Calibration									
	Wave/T	wist in Tul	oe !		Fit/Function		Out of	Sequence									

Picklist Print June-16-14 1:16:51 PM

Page 2

Work Order ID: 121039

D3436-044

Parent Item Name: Step RH

Parent Item:

121039

D3436-044

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 1.00

**

Required Qty: 1.00

D3436-1

Manufactured

No

155

Each

32.0000

Loc Code

Clamp

Location WA002

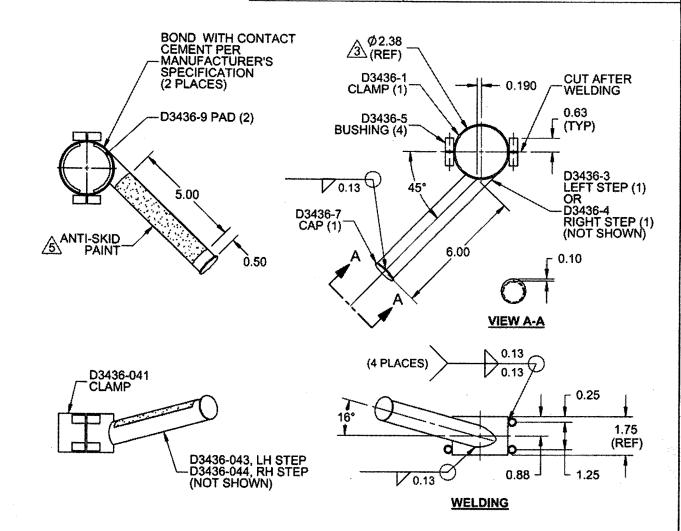
Loc Oty 32

32

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE												
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA			–	AEROSPACE	
QA Closed:		Date:							W	ork Order up	date only	<u> </u>	
Work Orde	r:				DISPOSITION			A	AGAINST DE	PARTMENT	PROCESS		
,				_	Rework	1		Skid-tube Cr	rosstube]	Water Jet	Engineering	
Part N	0.				Scrap			⊢	mall Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is			~ <u>~</u>	Finishing	1	e/Packaging	Other	
NCR N	o. <u> </u>				Suspected Unapproved			Large Fab Co	mposite		Supplier		
Root				Desci	iption of work order update	П	Initial	Action		Sign &	,		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descriptio	on	Date	Verification	QC Inspector	
Design				· .									
Doc/Data											·		
quip/Tooling													
landling/Pre	_												
Material	7												
Operator													
Offset/Setup	-								•				
Process	_												
upplier													
raining													
ransport								·					
Jnapproved		L	l			ΕΔI	IIIT CAT	L ΓEGORY					
Landin	g Gear		-		General	17	OLI CA	ILGORI			NA		
[Bending				Bend	Г	Folio/F	Program		Outside Dim	ensions [Pressure/Forced	
<u> </u>	Centre No	ot Conce	ntric		BOM/Route		Grain			Over/Under	 	Set-up	
-	Cracks				Broken/Damage/Defect	┢	Hardwa	ire		Part Incorrec	—	Temperature/Cure	
	Cracks Crimp/Kink/Ripple/Wave				Burrs		-	ion Incomplete/Unqual	lified	Part Lost/Mi	<u> </u>	Weld	
	Cuffs Cuffs				Contamination	一	1	tions Incomplete/Uncle		Part Moved	, <u> </u>	Wrong Stock Pulled	
Ī	Crushing				Countersink	<u> </u>	4	ned/off center		Positioned W	/rong	_	
	Heat Trea	it			Cut Too Short	-	Mislabe			Power Loss/S	Surge	Other	
	Inspection	n Strip in	Tube		Drawing		Misread	d					
	Marks/Ch	atter			Drill Holes		Off-set						
	Turning S	equence			Finish		Out of	Calibration					
	Wave/Tw	ist in Tul	ре		Fit/Function		Out of	Sequence			_		



DESIGN MB		DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	EPH-	APPROVED #	DRAWING NO.	REV. A SHEET 1 OF 4
05.04.28)4.28	MAINTENANCE STEP	SCALE 1:4
A 05.04.28		5.04.28	NEW ISSUE	



NOTES:

1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
2) WELD PER DART QSI 004
3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED (7) ALL DIMENSIONS ARE IN INCHES

30

RELEASED 05.05.27

ō

UNCONTROLLED COPY SUBJECT TO AMENDMENT WORK ORDER WITHOUT NOTICE

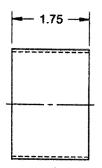
ENGINEERING

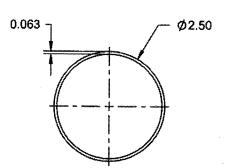
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



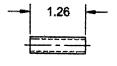
DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. A
TIL	I I	D3436	SHEET 2 OF 4
DATE		TITLE	SCALE
05.0)4.28	MAINTENANCE STEP	1:2

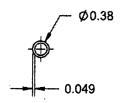




D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



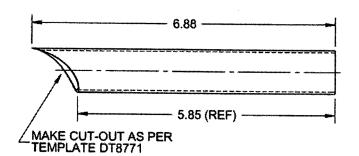
D3436-1/-5, GENERAL NOTES:

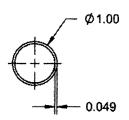
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.



DESIGN DRAWN BY MB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED -	DRAWING NO. D3436	REV. A SHEET 3 OF 4
05.04.28		MAINTENANCE STEP	SCALE 1:2

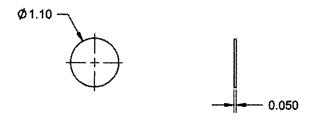




D3436-3 LEFT STEP

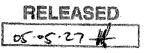
(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)



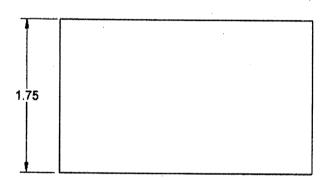
D3436-3/-7, GENERAL NOTES:

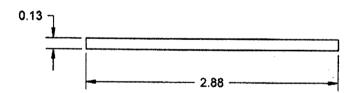
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

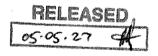
COPYRIGHT © 2005 BY DART AEROSPACE LTD.



DESIGN DRAWN BY MB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED #	D3436	REV. A SHEET 4 OF 4
05.04.28		MAINTENANCE STEP	SCALE 1:1







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S. 125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.